



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PC250-810
Job Sheet 176535



Part No: PC250-810

Job Qty: 6 ea

Part Name: Spring Cover



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/25/18

Job Tracking No:

Due Date: 5/11/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG PC250-810 Rev 1 IPP Rev A 18.04.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		5/11/18	0.00	0.00	Start Up Machining-2		
110	CNC Lathe	6 pcs		5/11/18	0.00	3.00	MORI NLX		
120	QC	6 pcs		5/11/18	0.00	0.00	QC2 Machining-4		
130	QC	6 pcs		5/11/18	0.00	0.00	QC8 Machining-4		
150	Outsource	6 pcs		5/11/18			GRO002-VC		
160	Packaging	6 pcs		5/11/18	0.00	0.00	Packaging2		
170	QC	6 pcs		5/11/18	0.00	0.00	QC6		
171	Small Fab	6 pcs		5/11/18	0.00	1.20	Small Fab-6		
172	QC	6 pcs		5/11/18	0.00	0.00	QC5		
180	Packaging	6 pcs		5/11/18	0.00	0.00	Packaging3-1		
190	QC21-SA	6 Ea		5/11/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FC014 FOLIO REV: _____ DWG REV: _____ 2-Debur

Descriptions: 120 - ***Engrave BATCH number using Marktronic engraver as per DWG.

150 - -Issue P/O to Groupe Altech; PO 039765 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required

171 - Laser engrave DART logo .

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R3.500	6061 Round Bar 3.50	.9150 ft (.1525 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R3.500	1	12	0



Container No: S066438



Part: PC250-810

Job No: 176535

Serial No/Batch: S066438

Revision: 1

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

1:52 PM dart.lacelle.linda

17

01/15 - 1/16

1/17

176 535
~~175612~~

DART AEROSPACE LTD		Work Order:
Description: Spring Cover		Part Number:
Inspection Dwg: PC250-810	Rev: 1	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.250	±.005	3.250	✓		Vern LPO9	
Ø2.125	±.005	2.128			↓	
Ø2.36	±.01	2.360			↓	
1.63	±.01	1.630			↓	
1.18	±.01	1.185			↓	
45°	±.5°	45°			Protractor	
1.31	±.01	1.312			Vern LPO9	
1.375	±.005	1.375			↓	
Ø.201	±.005	.202			↓	
Ø.38	±.01	.380			↓	
.87	±.01	.871			↓	
Ø2.735	±.005	2.733			↓	
45°	±.5°	45°			Protractor	
Ø2.419	±.005	2.420			Vern LPO9	
23°	±.5°	23°			Protractor	
.23	±.01	.235			Vern LPO9	
R.06	±.01	.062			↓	
.13	±.01	.131			↓	

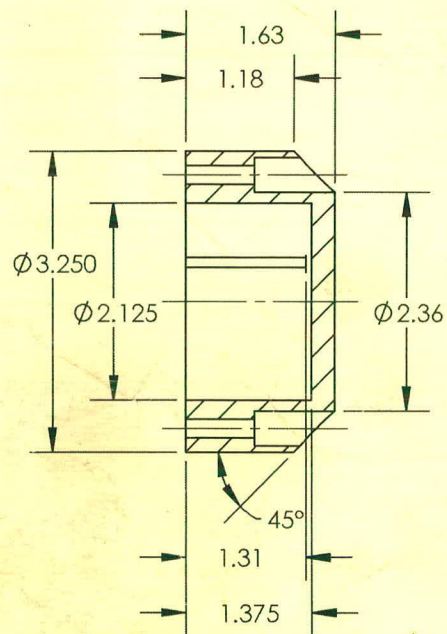
Measured by: <i>P</i>	Checked by: <i>B.F.</i>	QC Inspector:
Date: 18-04-28	Date: 18-04-30	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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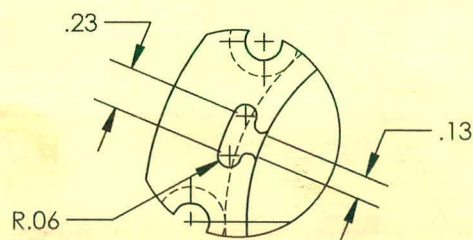
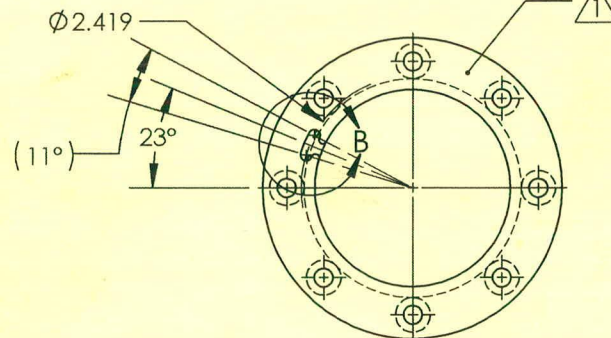
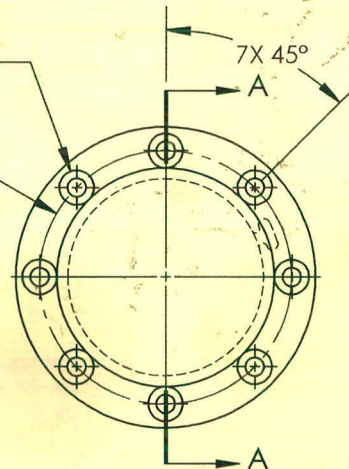
REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
		AS DRAWN BY APICAL.			6/10/2013	CFS
1	14-0128	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.			8/14/2014	DPD RW



SECTION A-A

8X $\varnothing$.201 THRU ALL
 $\square$ $\varnothing$.38 ∇ .87

$\varnothing$ 2.735 B.C.



DETAIL B
 SCALE 1 : 1

NOTE:

1 MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE SPRING COVER	
DWG NO. PC250-810	REV 1
MAT'L 6061-T6	
DRAWN BY: APICAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
APPROVED <i>D West</i>	
TREAT FINISH BLACK ANODIZE	
SPEC MIL-A-8625F, TYPE II, CLASS II	
USED ON MODEL	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 6/4/2004
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			PC250-810	1	SPRING COVER	6061-T6	$\varnothing$ 3-3/8 X 1-3/4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039765

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039765
PO Date: 5/1/18
Due Date: 5/4/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	176234	646.3910	Shim Issue P/O: _____ Cad Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	5/4/18	42 pcs	0 pcs	42 pcs	\$6.243333/pcs	\$262.22
2	175990	646.3912	Shim Issue P/O: _____ Cat Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	5/4/18	30 pcs	0 pcs	30 pcs	\$6.243333/pcs	\$187.30
3	176535	PC250-810	Spring Cover -Issue P/O to Groupe Altech; PO _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	5/4/18	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
4	173348	RBT400314- 7	Plate Weldment -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	5/4/18	4 pcs	0 pcs	4 pcs	\$6.15/pcs	\$24.60
5	173347	RBT400314- 1	Plate Weldment -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	5/4/18	2 pcs	0 pcs	2 pcs	\$25.75/pcs	\$51.50
Grand Total:										\$645.62

Order Notes

Plex 5/1/18 3:29 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(008887-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

008887 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
07-May-2018		Aman		039765				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	646.3910 SHIM Rev.	646.3910 SHIM CAD YELLOW PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM CH	42	42	0	0	0
2	646.3912 Rev.	646.3912 CAD YELLOW PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM CH	30	30	0	0	0
3	PC250-810 Rev.	PC250-810 01 -ANO-BLACK [ANODIZE BLACK] TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	6	6	0	0	0
4	RBT400314-7 Rev.	RBT400314-7 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT	ANODIZE CH	4	4	0	0	0
5	RBT400314-1 Rev.	RBT400314-1 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT	ANODIZE CH	2	2	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

